



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3172-041
Job Sheet 174509



Part No: D3172-041

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/11/18	0.00	0.00	Start Up Large Fab-5		4/18-04-13
100	Large Fab	1 pcs		4/12/18	0.00	25.00	Large Fab 8		4/2018-04-18
110	QC	1 pcs		4/12/18	0.00	0.00	QC9		PD 13-04-19
120	QC	1 pcs		4/12/18	0.00	0.00	QC5		PD 13-04-19
130	HandFinish	1 pcs		4/12/18	0.00	0.38	HandFinish2		REB 18-04-23
140	Powdercoat	1 pcs		4/12/18	0.00	1.04	Powdercoat1		SK 18-4-23
145	Packaging	1 pcs		4/12/18	0.00	0.00	Packaging3-1		2018-4-23
150	QC21-SA	1 Ea		4/12/18	0.00	0.00	QC21		21 APR 24 2018

Part Op 100 - 1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Drill holes in D3172-3 Descriptions: as per Dwg D3172 4-Deburr & Remove all markings from material 5-Weld all ribs as per Dwg D3172 using Welding Table 6- Weld top D3174-1 ONLY bottom ones will be welded after mesh is install as per dwg 7- Weld D5365-1 as per dwg in (2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front. 8- Weld mesh as per dwg 9- Use DT, 8996 jig to locate the bottom D3174-1 as per dwg

140 - 1ST COAT: START TIME: 1:15 OVEN TEMPERATURE: 375° FINISH TIME: 1:30.
***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-3	Basket Hinge	2 Ea (2 ea)	90-Start up Operation	5033173
D2327-3	Spacer Bushing	2 Ea (2 ea)	90-Start up Operation	5038301
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5049503599
D3166-1	Basket Hoop	4 Ea (4 ea)	90-Start up Operation	5050110
D3174-1	Mounting Lug	8 Ea (8 ea)	90-Start up Operation	F166104 → Bx
D5365-1	Lug	4 Ea (4 ea)	90-Start up Operation	5016368
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (48 ea)	90-Start up Operation	5049717
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	51 ft (51 ea)	90-Start up Operation	5008917 = 2 ft 5031514 = 48 ft

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2232-3	2	7	0
	D2327-3	2	4	0
	D2581	2	60	0
	D3166-1	4	9	0
	D3174-1	8	3	0
	D5365-1	4	4	0
	M304EX0.75-16F	48	903	0
	M304TS0.750W.065	51	585	0
Part Specifications				
Specifications could not be found.				

Plex 3/16/18 2:18 PM Dart.Gagnon.Michelle



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Container No: S052966



Part: D3172-041

Job No: 174509

Serial No/Batch: S052966

Revision:

Inspector:

Date: 03/20/18

Master Unit 001782



Job No 174509